

Work Order ID 54216

December 03, 2009 12:33:39 PM



Page 1

Item ID: D212-664-101

Accept



Setup Start



Revision ID:

Item Name: Crosstube Fwd

Stop



Start Date: 12/3/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 12/22/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

RL

Date: 09-12-3

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D212-664-141

Rev D

100



DOCUMENT CONTROL

0.00

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels as per PPP D212-664-101 CHG003

SL RAL

110



Pick Kit

0.00

Packaging

Packaging

Memo

0.00

Packaging

120



BENDING MACHINE - CROSSTUBES

0.00

CNC Bend 2

Memo

0.00

CNC Alpha 160 Bender

Bend tube as per Dwg D212-664-141 using CNC bender program 212-fw and Folio FT015






MD 09-12-09

PTO

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
9-12-9	120	- Tube overheat 1" on 1 side - side B	 10/02/17 QST042	- Verify wall thickness w/ ultra sonic. Minor abnormalities Found. - Scrap & Destroy RC:- Process	 10/02/16 9-12-09	 10/02/17	 10/02/17 QST042	 10/02/17

NOTE: Date & initial all entries

Wall thickness
D-212-664-101
B-54216

Side A	Side B
1- .209	1- .186
2- .235	2- .205
3- .205	3- .232
4- .293	4- .262
5- .310	5- .287
6- .338	6- .317
7- .365	7- .347
8- .373	8- .373

WB 09-12-09

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Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



QC

Quality Control

QC15- Crosstube Dimensional Check

0.00

Memo

0.00

140



Crosstubes

Crosstubes

Crosstubes

Memo

0.00

1-Drill pilot holes in tube as per Dwg D212-664-141 using drill Jig DT8548 & DT8549

2-Ream hole to finish size in tube as per Dwg D212-664-141 using drill Jig DT8548 & DT8549. Check dimensions between holes, both sides on both cuffs, to ensure alignment with saddle holes.

3-Scribe part # and batch # using vibrating stylus as per Dwg D212-664-141

4-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D212-664-141

SC RPP

W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150



HandFXtube

Crosstubes Chemical Conversion

0.00

Memo

0.00

Hand Finishing Crosstubes

Chemical Conversion Coat within 24 hours of bending and drilling

160



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

170



Outsource2

Outsource process - NDT

Outsource process - NDT per QSI038 4.1

0.00

Memo

0.00

Liquid Penetrant Inspection as per QSI038
Issue P/O: _____
LPI as per ASTM 1417 Level 2
Attach copy of NDT results to work order

Scrap

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Cust Item ID:

Required Date: 12/22/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180



Packaging

Packaging

Receive & Inspect for Damage & Mat'l Certs
Packaging

0.00

Memo

0.00

Ensure copy of NDT results attached to work order.

190



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Inspect for damage & ensure results are as per Dwg D212-664-141

Scanned

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

200

Spray Painting per QSI005 4.2

0.00



SprayPaint

Memo

0.00

Spray Painting

1-Prime inside and outside crosstube as per QSI 005 4.2
2-Paint outside crosstube with White Imron as per QSI 005 4.2

PRIME:

Start Time: _____

Finish Time: _____

PAINT:

Start Time: _____

Finish Time: _____

210

QC14- Inspect Spray Paint

0.00



QC

Memo

0.00

Quality Control

Then, Wrap in plastic bag to protect from scratches

Scrap

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Start Date: 12/3/2009 Start Qty: 1.00

Required Date: 12/22/2009 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: Date:

Tooling: Date:

Run Start

QC: Date:

SPC (Y/N): Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

220

0.00



Crosstubes

Crosstubes

Memo

0.00

1- Lightly scuff the bonded area using a 320 grit sand paper and clean the area with 41058 wash 'n' wipe
2-Install supports with magnobond as per QSI 015 Adhere for for 12 Hrs
A/R 6398 Magnobond Batch: _____

230

0.00



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

240

0.00



Packaging

Packaging

Pick Kit

Memo

0.00

SCN 176

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 54216



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Item ID: D212-664-101

Accept



Setup Start



Revision ID:

Item Name: Crosstube Fwd

Stop



Start Date: 12/3/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 12/22/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

250

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

260

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D212-664-101

270

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

Scanned

*MF
10-2-17*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 54216

Parent Item: D212-664-101RevC

Parent Item Name: Crosstube Fwd

Comments: IPP RevH: as per ECN09-696 09.11.19 DD verified by:EC

Start Date: 12/3/2009

Required Date: 12/22/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D212-664- 101TRNRevC		Manufactured	No			110	Each	2.0000	1.0000			



Crosstube Turning Detail



13-54284

MB 09-12-09

D3595-063-450RevA

Manufactured

No



RUBBER CUSHION

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FG

2

53256

1

53257

1

230

Each

188.9689

4.2105



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

LG

84

52447

84

Main Warehouse

ST

104.9689

38959

2

43210

2.59

46465

0.3789

53775

100

SNAP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 2

Work Order ID: 54216

Parent Item: D212-664-101RevC

Parent Item Name: Crosstube Fwd

Comments: IPP RevH: as per ECN09-696 09.11.19 DD verified by:EC

Start Date: 12/3/2009

Required Date: 12/22/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21920-25		Purchased	No			220	Each	201.0000	4.0000			
Clamp(per MIL-DTL-8783C)												

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST	201
107456	2
108111	3
108975	17
109181	42
109644	10
111282	4
111429	1
112495	22
112919	25
113281	25
113282	50

SNAP

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 3

Work Order ID: 54216

Parent Item: D212-664-101RevC

Parent Item Name: Crosstube Fwd


Comments: IPP RevH: as per ECN09-696 09.11.19 DD verified by:EC

Start Date: 12/3/2009

Required Date: 12/22/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2893-1RevB		Manufactured	No			220	Each	72.0000	2.0000			
												
2.75 Support												

Warehouse
Location

Main Warehouse

ST

72

25657

6

47109

2

47637

16

51775

19

53125

19

53340

10

D3428-1RevA

Manufactured No

240

Each

11.0000

1.0000

Placard

Warehouse
Location

Main Warehouse

ST096

11

50790

11

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Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 54216

Parent Item: D212-664-101RevC

Parent Item Name: Crosstube Fwd

Comments: IPP RevH: as per ECN09-696 09.11.19 DD verified by:EC

Start Date: 12/3/2009

Required Date: 12/22/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

AN6-35A

Purchased

No

240

Each

58.0000

4.0000



BOLT

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

58

112314

38

112805

20

AN6-36A

Purchased

No

240

Each

123.0000

4.0000



Bolt

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

123

109632

1

110382

2

112314

70

113121

50

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Parent Item Name: Crosstube Fwd


Comments: IPP RevH: as per ECN09-696 09.11.19 DD verified by:EC

Start Date: 12/3/2009

Required Date: 12/22/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21042L6  Nut		Purchased	No			240	Each	524.0000	6.0000			

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST	524	
105077	22	
110002	5	
111548	8	
111578	400	
112492	89	

AN960JD616



Washer

Purchased

No

240 Each 847.0000 18.0000

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST	847	
112314	47	
112828	500	
113149	300	

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Shop Packet Print

Page 5

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

List Lots

Page 1 of 1

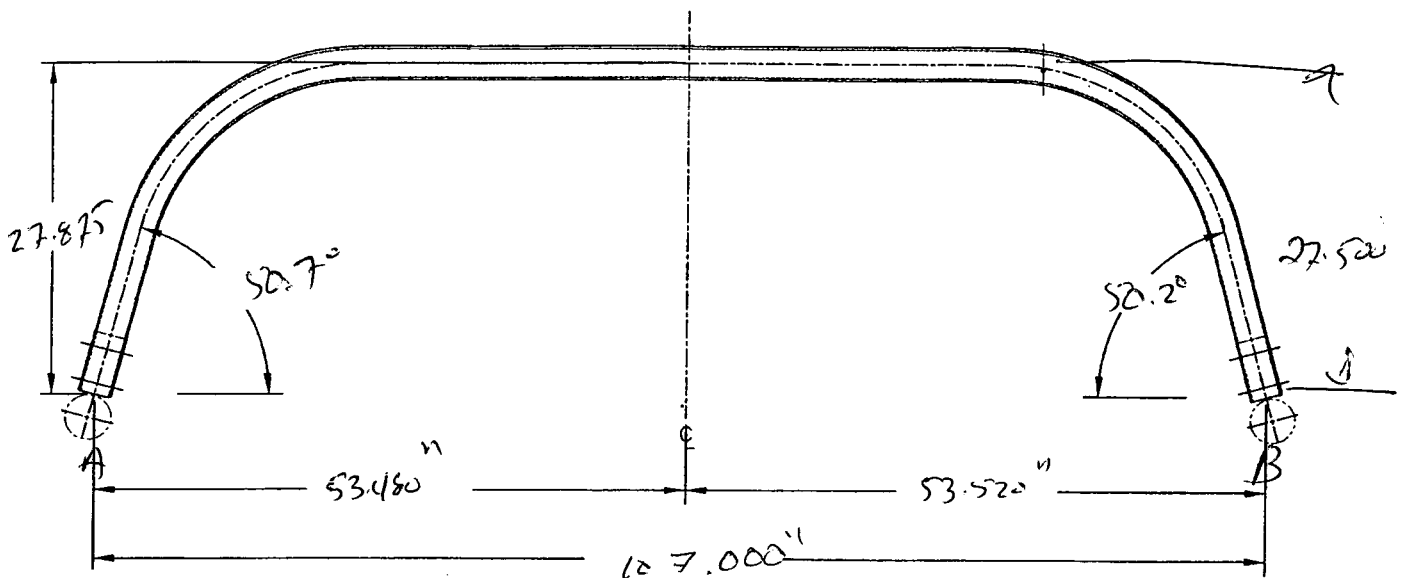
December 11, 2009 8:03:34 AM

Criteria : Item ID: d6005-128 All Locations All Warehouses All Quantity

Item ID Item Name	Warehouse ID Location ID	Lot Number	Last Trans Date	Lot Qty	Shelf Life Dt	Type Code	Comments
D6005-128	Main Warehouse	34686	12/05/09	1.0000		QC21	
Crosstube Material	LG						
	Main Warehouse	38337	12/09/09	3.0000		QC21	
	LG						
			Total:	4.0000			

DART AEROSPACE LTD		Work Order:	54211p
Description: Crosstube High Fwd (205/212/412)		Part Number:	D212-664-101
Inspection Dwg: D212-664-141 Rev: C		Page 1 of 1	

Required Dimension	Min	Max
Height	26.79	27.05
1/2 Span	53.59	53.85
Angle	49	52
Total Span	107.18	107.7



Comments

QC15 Inspection	
Date	

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	
B	07.05.31	Dimensions updated per Dwg Rev C	KJ/JM	

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Item	Qty -141	Qty -141B	Part Number	Description
1	X		D212-664-141	CROSSTUBE ASSEMBLY (205/212/412 HIGH FWD)
2		X	D212-664-141B	CROSSTUBE ASSEMBLY (214 HIGH FWD)
3	1	1	D6005-128	CROSSTUBE
4	2	2	D2893-1	SUPPORT
5	4	4	D3595-063-450	RUBBER CUSHION
6	4	4	MS21920-25	CLAMP (OR MS21920-26)
7	A/R	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)

GENERAL NOTES:

- MATERIAL: MANUFACTURED FROM D6005-128
FINISHED LENGTH = 126.514±0.020
- FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED.
- BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- IDENTIFICATION: SCRIBE DART PART NUMBER "D212-664-XXX" AND BATCH NUMBER ON INSIDE OF CUFF
USING VIBRATING STYLUS
- WEIGHT: D212-664-141 = 33.6 lbs (PER IIN-D212-664)
D212-664-141B = 33.6 lbs (PER IIN-D212-664)
- PART IS SYMMETRIC ABOUT CENTERLINE.
- RUN CUTTER OFF PART. BLEND OUT EDGE LONGITUDINALLY. TRANSITION SHOULD BE SMOOTH.
- BEND PROGRESSIVELY WITH A MINIMUM OF 3 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- INSTALL D2893-1 SUPPORT USING 0.03" TO 0.05" THICK LAYER OF MAGNOBOND 6398 TO THE SURFACE OF D2893-1 THAT WILL BE IN CONTACT WITH THE CROSSTUBE PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- INSTALL MS21920-25 CLAMPS (OR -26) WITH D3595-063-450 RUBBER CUSHIONS TO SECURE THE D2893-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE OF CROSSTUBE SUPPORT.
- EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

SPECIFY
 REFERENCE
 ENCLOSURE
 UNCONTROLLED
 CONTACT POINT
 WITH THE
 WORK
 NO. 54216
 1004-12-3

RELEASED
 2009-10-29
 M

D	REFORMAT/REVISE GENERAL NOTES/PART LIST; REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENT STANDARDS; ADD -141B (ZN B4-2, D4-2); REMOVED REF & ADD TOLERANCES (ZN B4-3, C6-3, C8-3 & B6-3); RELOCATED FLAG #6 PER PAR 08-046 (ZN A5-3); MOVED TURNING DETAIL & UPDATED TOLERANCE TO SHEET 4	RF	09.09.30
C	REMOVE -851 ABRASION STRIP; ADD MAGNOBOND 6398, CUSHION, REVERSE CLAMPS	PH	07.03.08
B	ADD HOLES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	PH	05.02.04
A	NEW ISSUE	PH	00.12.12
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. D
MFG. APPR.	PH	D212-664-141	SHEET 1 OF 4
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	XTUBE ASS'Y (205/212/412 HI FWD)	NTS
DATE	09.09.30	COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

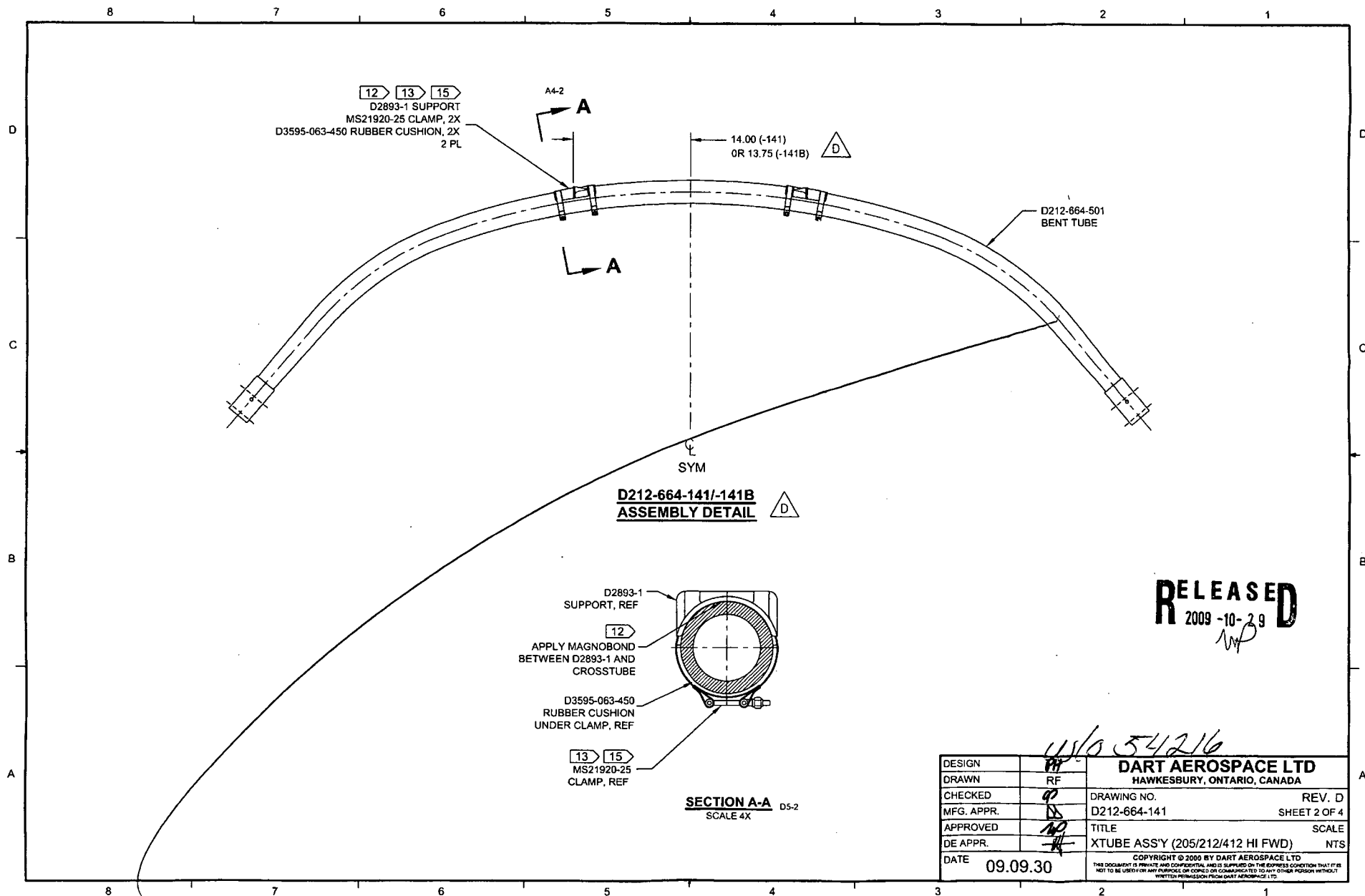
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



RELEASED
2009-10-29

DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	9P	DRAWING NO.	REV. D
MFG. APPR.	DS	D212-664-141	SHEET 2 OF 4
APPROVED	14P	TITLE	SCALE
DE APPR.	14P	XTUBE ASS'Y (205/212/412 HI FWD)	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

D212-664-501
BENDING AND DRILLING DETAIL

10 D

RELEASED
2009-10-29

W10 54214

VIEW C-C: CUFF DETAIL
SCALE 3X

C2-3

SECTION B-B
SCALE 4X

C4-3

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. D
MFG. APPR.	PH	D212-664-141	SHEET 3 OF 4
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	XTUBE ASS'Y (205/212/412 HI FWD)	NTS
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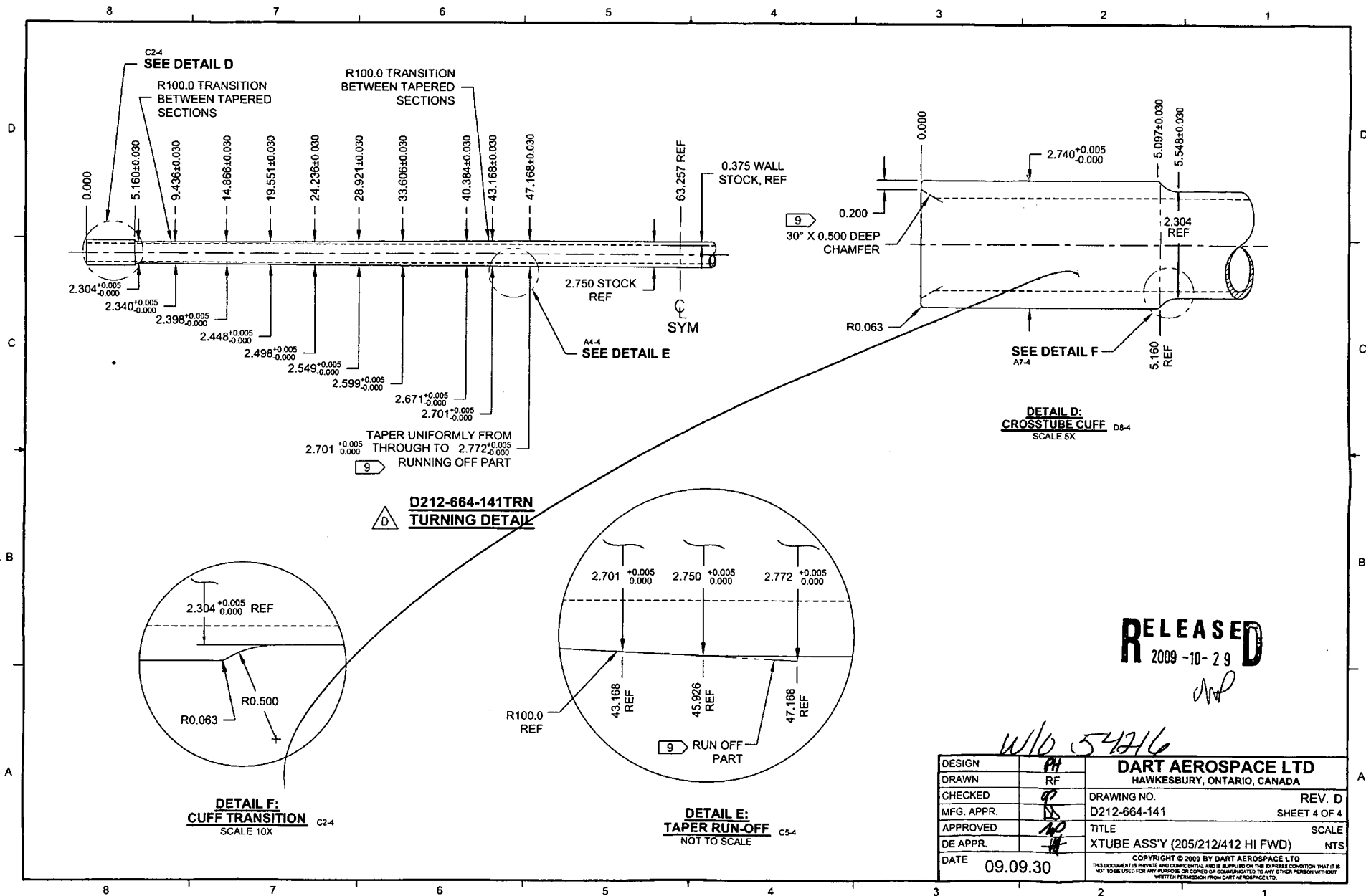
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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W/O:		WORK ORDER CHANGES					
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